

Work Order ID 72632

Wednesday, August 03, 2011 10:14:58 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4331-1
Revision ID: PRELIM
Item Name: Doubler

Accept



Setup Start



Stop



Start Date: 8/3/2011 Start Qty: 1.00
Required Date: 8/5/2011 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals:

Process Plan:

H

Date:

11083

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4331

PA6

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4331 ☐

Dwg Rev: *PA6* ☐

Prog Rev: *PA6* ☐

2-Deburr if necessary

BIT 8-3

(2)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

BIT 8-3

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*- inspected to PA6
Dwg only + no holes
Subtotal of 20*

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

FORM AS PER DWG

0.00

0.00

JB 11/08/08

0

PTO

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

- inspect to Handwritten

Pass Dn only

8/10/08

PTO

160



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

1X 0 m 14/08/08

Dart Aerospace Ltd

W/O: 72632		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-08-08	130	take one for test bench	SA	11/08/08	1	U 11-08-08	

Part No: D4331-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	131							

NOTE: Date & initial all entries

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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 \$ 11.08/08

180

Identify as per dwg & Stock Location: -041

0.00



Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 11/08/08 AUTH W

RELEASED _____ DATE _____

11.08.08

Picklist Print

Wednesday, August 03, 2011 10:15:04 AM

Work Order ID: 72632



Parent Item: D4331-1



Parent Item Name: Doubler



Start Date: 8/3/2011

Required Date: 8/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 11-07-05 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080 		Purchased	No				sf	200.3000		1.631579		3, B11-8-3	
2024-T3 .080 sheet													

Location

Loc Qty

Loc Code

MAT022

200.3

105411

6

109424

4

110347

0.5

112331

3

113796

7

114025

15.7

116604

5.8

117392

40.1

118180

118.2

118180

②

DART AEROSPACE LTD		Work Order:	72335
Description: Doublon		Part Number:	D4331-1
Inspection Dwg: D4331	Rev: PA3 mark up:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X

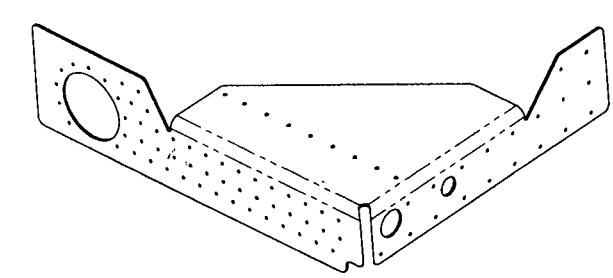
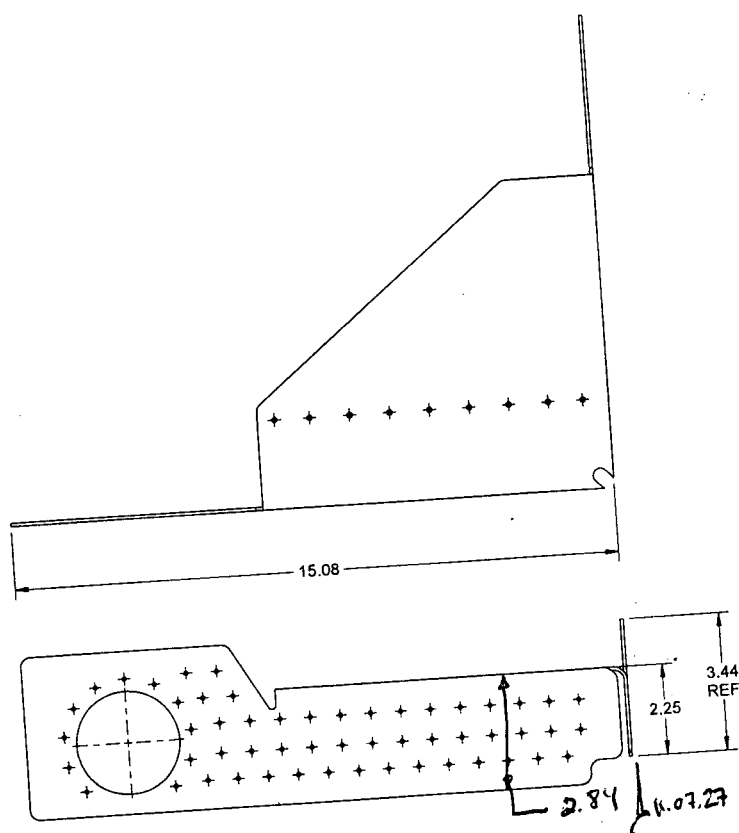
First Article

Prototype

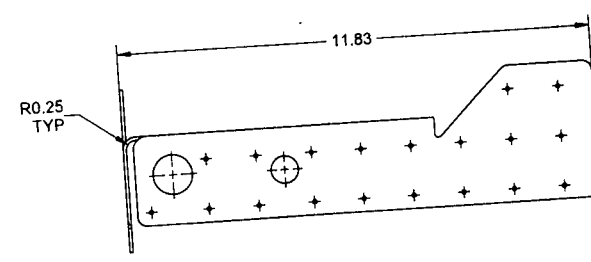
[illegible]

Measured by: <i>SB</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: <i>11/03/08</i>	Date: <i>11/06/06</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



72335



D4331-1 DOUBLER

PRELIMINARY ISSUE
11.02.03

- NOTES:**
- 1) MATERIAL: MADE FROM D4331-1F
 - 2) FINISH: PRIME PER QSI 005 4.2.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4331	SHEET 3 OF 9
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	11.02.03	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

